

Work Order ID 95031 - 2

January-02-13 12:48:25 PM

95031

Page 1

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 1/16/13

Start Qty: 8.00

Required Date: 1/16/13

Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLC

Date: 13-01-03 Tooling:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3494

Rev D

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 0

Prog Rev: 0

304.063

2-Deburr if necessary

110

QC 2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

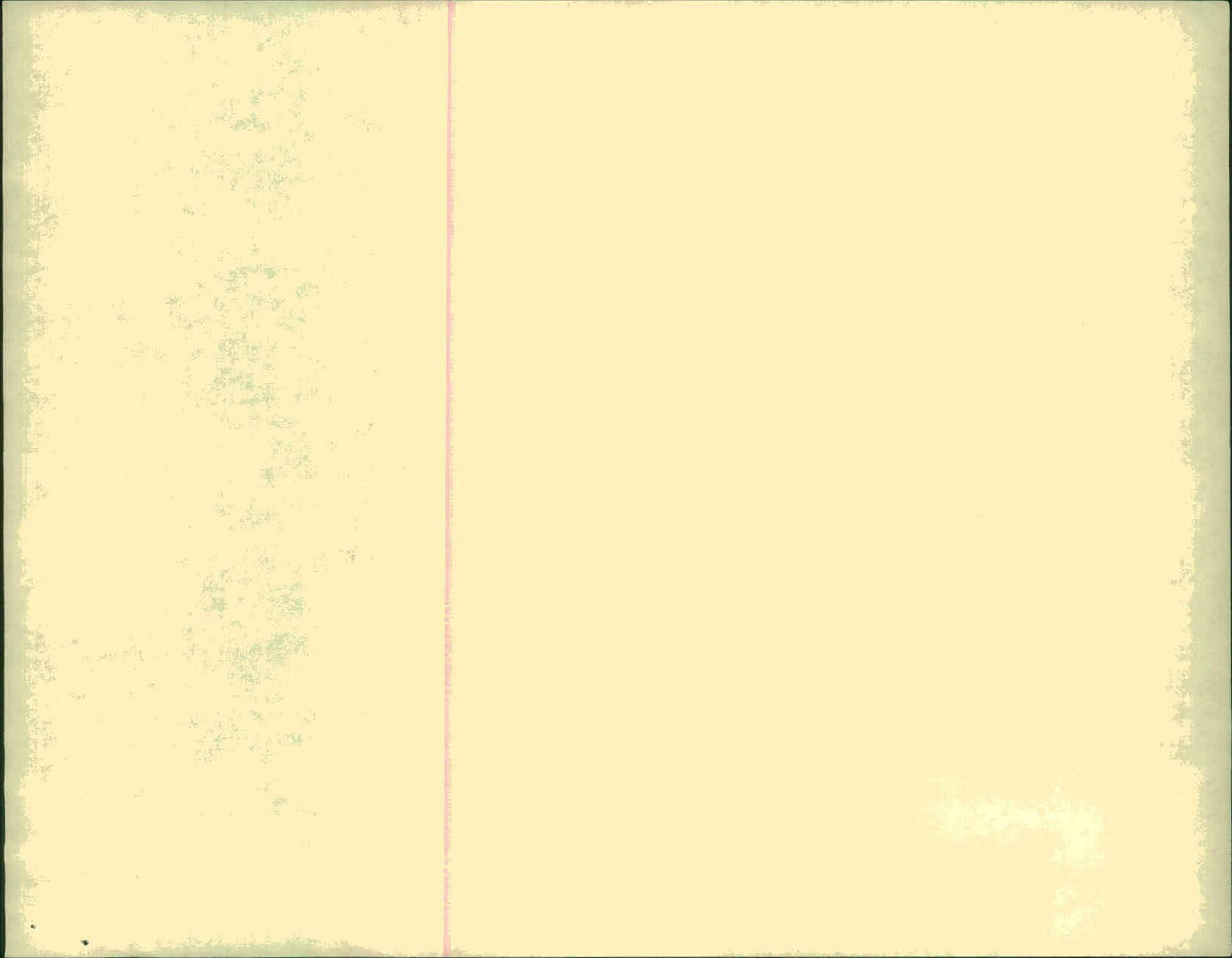
Quality Control

20

Jm 13-1-29

20

Jm 13-1-30



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Page 2

Item ID: D3494-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stub Cover

Start Date: 1/16/13 Start Qty: 8.00

8

Required Date: 1/16/13 Req'd Qty: 8.00

8

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00 13 1 30

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

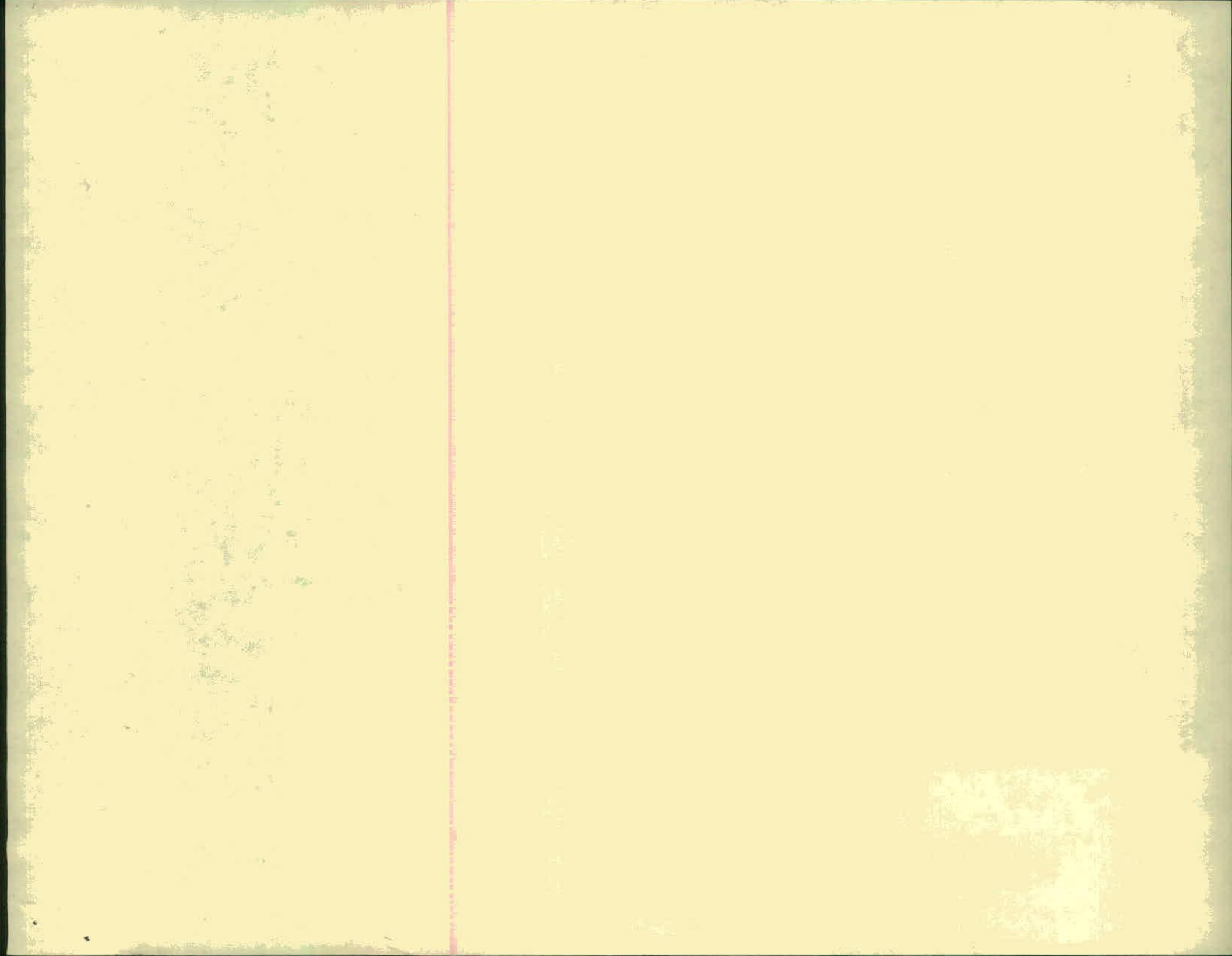
QC

Memo

0.00 13-2-1

Quality Control

20
20
SA
13/30/30



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Page 3

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 1/16/13 Start Qty: 8.00

Required Date: 1/16/13 Req'd Qty: 8.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

144

Weld per dwg A/R S.S. rod Batch: *m118161*

0.00

144

Large Fab

Memo

0.00

Large Fab

1- WELD

2- GRIND AS PER DWG

X12

13-02-06 MAL

146

QC10- Inspect visual per QSI004- ground welds

0.00

146

QC

Memo

0.00

Quality Control

(12)

13-02-06

*DAS
09
2-83*

147

QC5- Inspect part completeness to step on W/O

0.00

147

QC

Memo

0.00

Quality Control

(12)

13-02-06

*DAS
09
2-83*

28
02
75

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Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 1/16/13 Start Qty: 8.00

Required Date: 1/16/13 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

Black Sandtex (Ref 4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

Memo

0.00

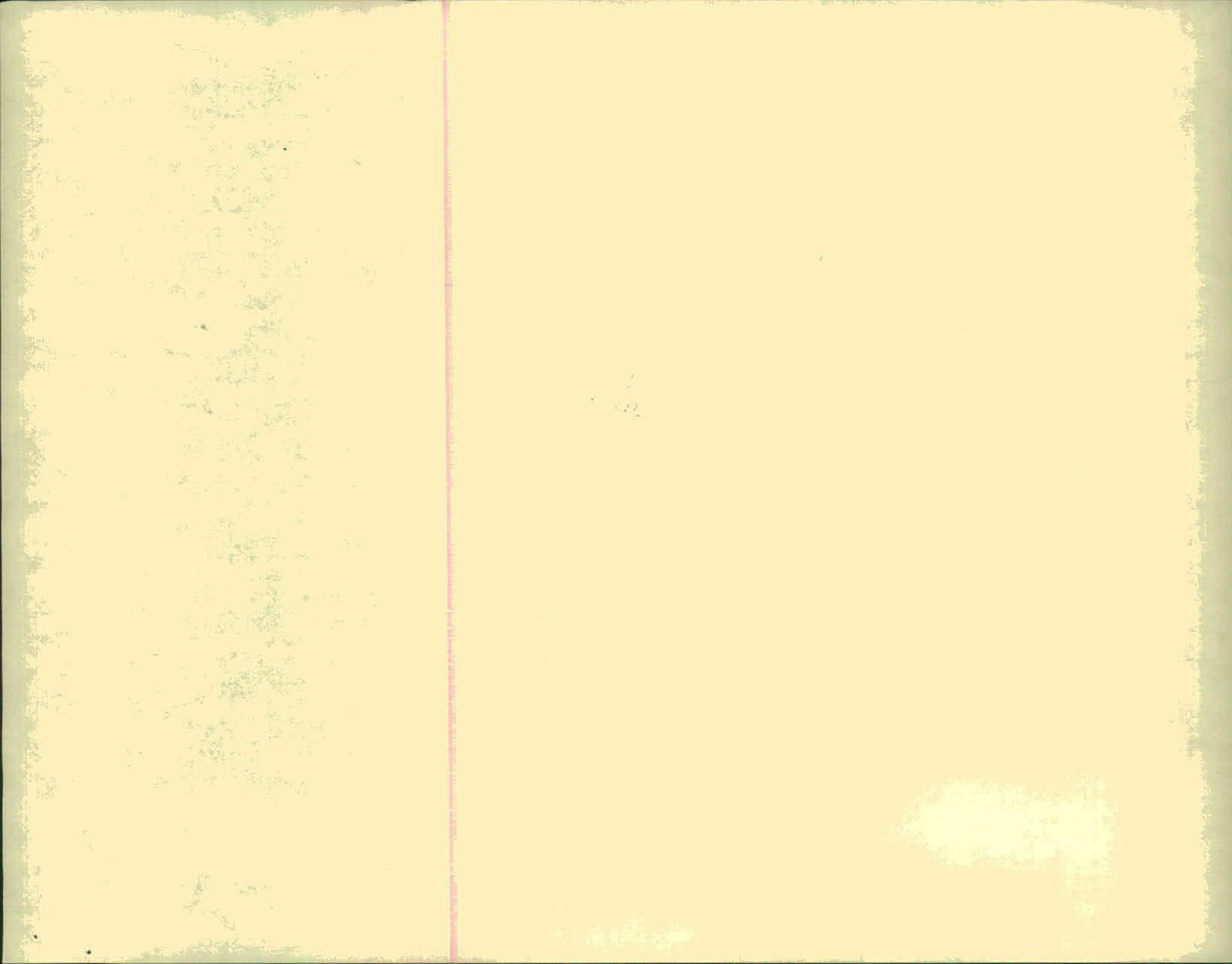
12 cf BL 13-2-11.

10AS 15 13-2-11

12

12x

SP 13-2-11



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Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 1/16/13 Start Qty: 8.00

Required Date: 1/16/13 Req'd Qty: 8.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

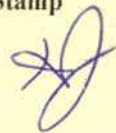
180

QC

Memo

0.00

Quality Control

13/2/14 
CMP

B-2-12



Picklist Print

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Page 1

Work Order ID: 95031
 Parent Item: D3494-1
 Parent Item Name: Stub Cover

Start Date: 1/16/13

Required Date: 1/16/13

Start Qty: ~~200~~

Required Qty: ~~200~~

Comments: IPP Rev:A New Issue 06-05-18 JLM
 IPP rev B een 888 06.12.13 EC
 10.03.03 verifie by:EC
 lpp RevD ECN 10-555 chg design EC verified by:DD
 IPP Rev:C add welding DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	220.2560	0.72	6.0631576			

Location

MAT020

122245

123136

124428

Loc Qty

220.256

13.156

207.1

Loc Code

124428

Jm 13-1-21



DART AEROSPACE LTD		Work Order:	75051
Description: Stub Cover		Part Number:	D3494-1
Inspection Dwg: D3494	Rev: D	Page 1 of 1	

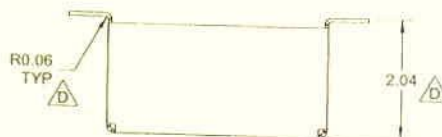
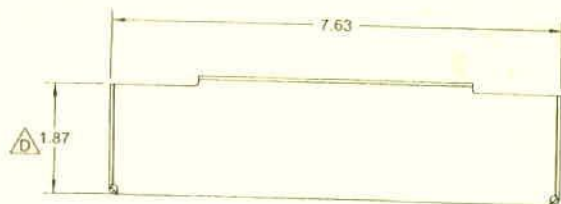
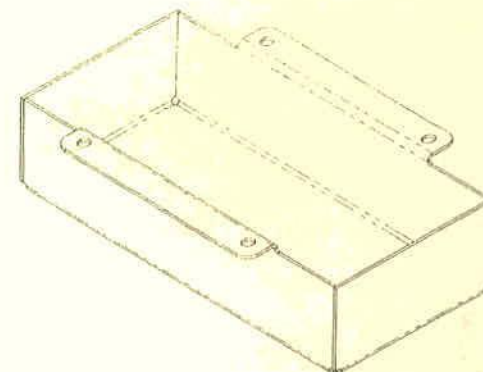
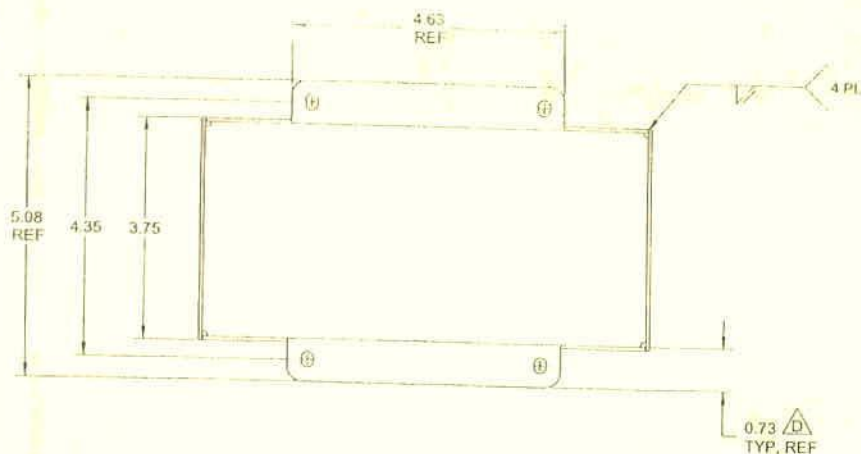
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.208	+/-0.010	0.208"	-		✓	Jkmo1
0.368	+/-0.010	0.369"	-		✓	
0.766	+/-0.010	0.772"	-		✓	
→ 2.585 2.528"	+/-0.010	2.530"	-		✓	
6.278	+/-0.010	6.281"	-		✓	
8.039	+/-0.010	8.043"	-		✓	Pict 5302
8.437	+/-0.010	8.440"	-		✓	
8.805	+/-0.010	8.812"	-		✓	
1.832	+/-0.010	1.830"	-		✓	
3.262	+/-0.010	3.265"	-		✓	
3.604	+/-0.010	3.610"	-		✓	
3.940	+/-0.010	3.940"	-		✓	
7.544	+/-0.010	7.549"	-		✓	
7.887	+/-0.010	7.885"	-		✓	
9.317	+/-0.010	9.321"	-		✓	
11.148	+/-0.010	11.153"	-		✓	
0.060	+/-0.010	0.060"	-		✓	

Measured by: Jm	Audited by: Jm	Preliminary Approval:
Date: 13-1-20	Date: 13-1-20	Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	10.02.18	Dimensions updated per Dwg Rev C	KJ	
C	11.04.28	Dimensions updated per Dwg Rev D	KJ	





D3494-1 STUB COVER

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.29 lbs
- 8) WELD PER DART QSI 004

95031 MCT
13 01-03

RELEASED
2010-04-26

4.350
4.350
4.310

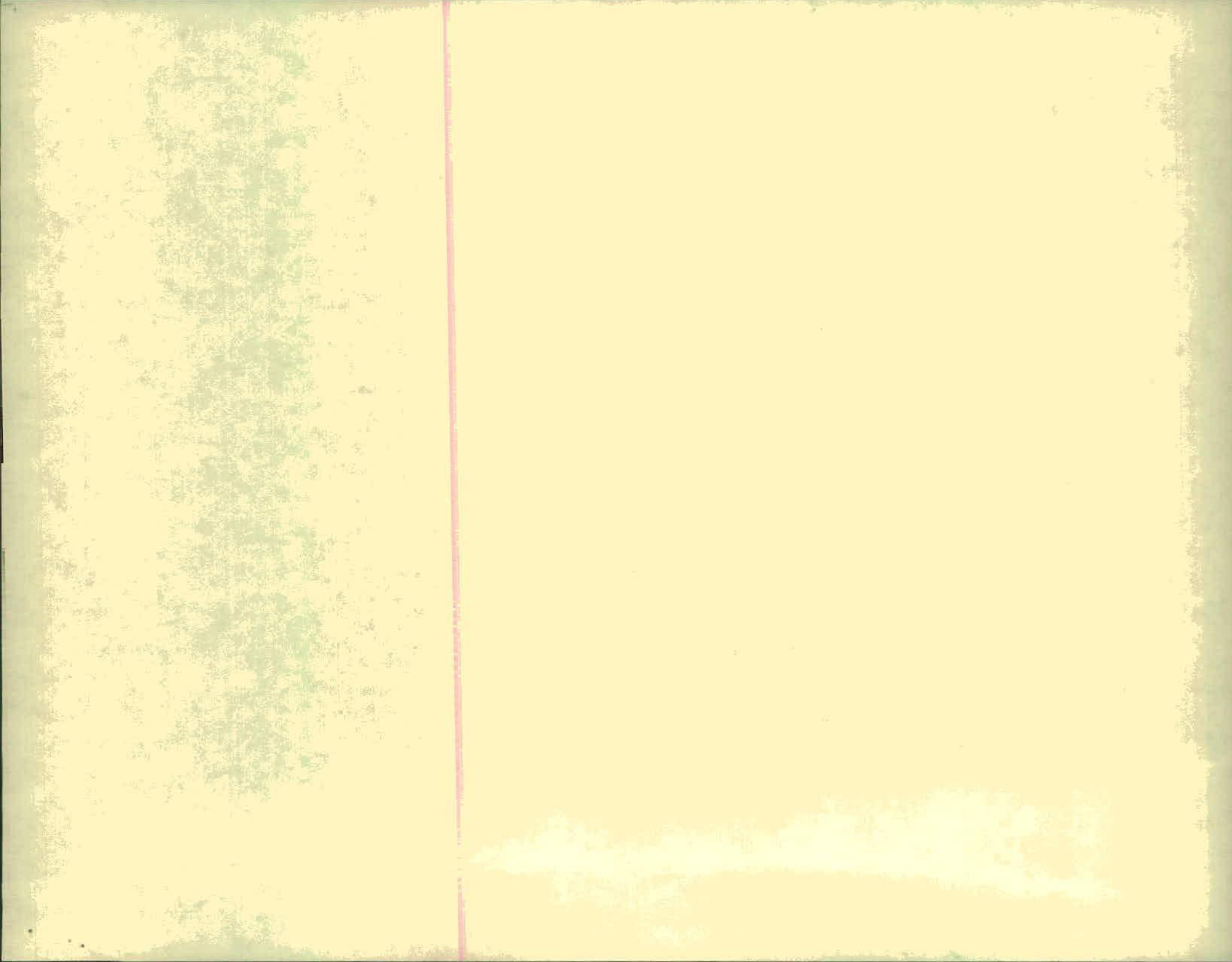
D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1); 1.87 WAS 1.86 (ZN B8-1); 2.04 WAS 2.00 (ZN B3-1); REVISED D3494-1F (ZN A8-2); CORRECTED WEIGHT INFO (ZN A8-1); UPDATED MATERIAL (ZN A8-2) REASON: SEE NCR#10-037	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE; GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT" C5-1 0.67 DIM WAS 0.65, B8-1 1.00 DIM WAS 1.86 B3-1 & 2.04 DIM WAS 2.00 REFER TO PAR 08-003 FOR FURTHER DETAILS	AJS	08.10.31
B	REVISED FLAT PATTERN; BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.12.28
A	NEW ISSUE	MB	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

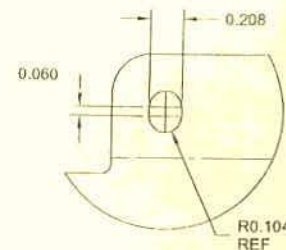
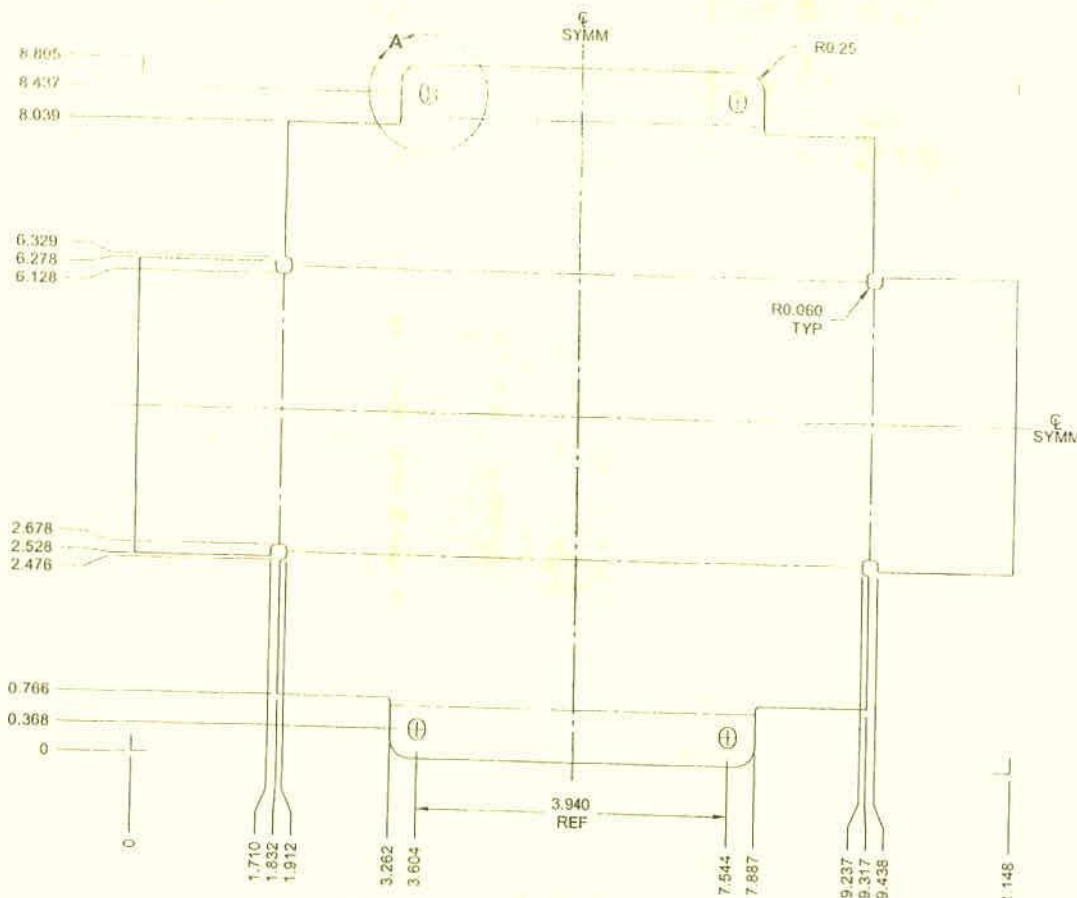
DRAWING NO. **D3494** REV. D
SHEET 1 OF 2
TITLE **STUB COVER** SCALE NTS

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4.350
4.350
4.310



95031



DETAIL A
SLOT DETAIL 4 PL
SCALE 2X

D3494-1F STUB COVER FLAT PATTERN

RELEASED
2010-04-26
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.060 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE COMPLETED PART WEIGHT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. D
MFG. APPR.		D3494	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
DATE	10.04.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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